

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017663**Date Inspected:** 22-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison was present at Yerba Buena Island in California between the times noted above for observations relative to the work being performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below.

- 1). OBG Field Welding of East Line Lifting Lug Access Hole Inserts - (SMAW)
- 2). OBG Field Splice of Ventilation Access Insert Weld 2E PP13.5 E2 SW (QAI Verification)
- 3). OBG Field Splice 7W/8W Weld ID: A2 Face A - (QA observation of QC UT results)

- 1). OBG Field Welding of East Line Lifting Lug Access Hole Inserts - (SMAW)

Exterior: PP9.5 and PP17

The QAI periodically observed the fit-up and welding per the Shielded Metal Arc Welding (SMAW) process in the 1G (flat) position to restore the Lifting Lug Access holes in the A deck at PP9.5 and PP17. The QAI observed AB/F approved welder Darcel Jackson (ID 9967) welding at PP9.5 weld E3-1 that had been previously completed but later removed due to the insert being the wrong thickness. Mr. Jackson completed the welding from the exterior utilizing copper backing. The QAI observed that AB/F approved welder Eric Sparks (ID 3040) performed fit-up and welding at PP17 weld E3-1. Mr. Sparks did not complete the welding from the exterior due to inclement weather. Mr. Sparks also utilized copper backing. QC Inspector Mike Johnson was periodically present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1050A. Work at this location appeared to be in general compliance with contract documents.

- 2). OBG Field Splice of Ventilation Access Insert Weld 2E PP13.5 E2 SW (QAI Verification)

The QAI performed verification Ultrasonic Testing (UT) of 10% of the length of OBG Field Splice of the

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Ventilation Access Insert Weld at 2E PP13.5 E2 SW. The Insert Weld at 2E PP13.5 E2 SW verified by the QAI appeared to be in general compliance with contract documents. See Ultrasonic Testing Report Form TL-6027 generated by the QAI on this date.

3). OBG Field Splice 7W/8W Weld ID: A2, Face A – (QA observation of QC UT results)

The QAI arrived at the OBG Field Splice 7W/8W Weld ID: A2, Face A and observed that the QC UT had been completed previously by QC Inspector Steve McConnell. The QAI noted indications at the following locations with the following lengths:

- 1) Y = 500mm Length = 20mm
- 2) Y = 575mm Length = 60mm
- 3) Y = 1230mm Length = 125mm
- 4) Y = 1510mm Length = 95mm
- 5) Y = 1725mm Length = 215mm
- 6) Y = 2090mm Length = 150mm
- 7) Y = 2535mm Length = 35mm
- 8) Y = 2640mm Length = 290mm
- 9) Y = 2810mm Length = 20mm
- 10) Y = 3145mm Length = 340mm



### Summary of Conversations:

The QAI was approached by QC Lead inspector Bonafacio Daquinag Jr. who stated that there was a weld that has been accepted by QC and is ready to be released to METS for verification testing. Mr. Daquinag identified the area as the ventilation access hole insert weld at 2E PP13.5 E2 SW.

Other conversations on this date with Quality Control Inspectors were general in nature and pertained to locations of welding and QC activities.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammed Fatemi (916) 813 3677, who represents the Office of Structural Materials for your project.

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Inspected By: Madison, Bert

Quality Assurance Inspector

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**Reviewed By:**      Levell,Bill

QA Reviewer